

Work Order ID 152484***152484***

Page 1

Monday, October 24, 2016 1:41:45 PM

Item ID: D4154-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 10/24/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/28/2016 Req'd Qty: 10.00

10

Customer:

Reference:

DAS
21
9-29

Approvals: Process Plan:

Date: OCT 24 2016
Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4154	F

100

0.00

100

Waterjet

Memo

0.23

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: FProg Rev: F

2-Deburr if necessary

(10)

22/10/24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

(10)

22/10/24

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.03

Quality Control

OCT 25 2016

130

Form as per dwg

0.03

130

Brake NC

Memo

0.08

Brake NC

NOV 02 2016

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.03

Quality Control

NOV 03 2016

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Cust Item ID:

Required Date: 10/28/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: WA001

0.00

150

Packaging

Memo

0.02

Packaging

LOCATION: WA001

10

16-11-16
jm

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.17

Quality Control

DAS
21
9-89

NOV 17 2016

Picklist Print

Monday, October 24, 2016 1:41:51 PM

Work Order ID: 152484

152484

Parent Item: D4154-1

D4154-1

Parent Item Name: Plate

Start Date: 10/24/2016

Required Date: 10/28/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC
15.10.16 AS PER DWG REV.F7 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	153.8240	4.2697	44.94421			

M304S18GA

**

2-16/10/24

304/316 .050 Sheet

Location	Loc Qty	Loc Code
MAT020	65.3	
M133328	55.224	
M133587	0.7	
M134824	4.875	
M134982	18.825	
M135779	65.3	(32)
MAT20	8.9	
M134580	8.9	

(32)

DART AEROSPACE LTD		Work Order: 152484
Description: Plate		Part Number: D4154-1
Inspection Dwg: D4154	Rev: F	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	.399	1			
0.450	+/-0.010	.448	1			
0.125	+/-0.010	.126	1			
0.38	+/-0.030	—	1			
0.88	+/-0.030	.883	1			
1.19	+/-0.030	—	1			
5.273	+/-0.010	5.272	1			
6.42	+/-0.030	6.423	1			
5.223	+/-0.010	5.221	1			
6.72	+/-0.030	6.723	1			
40.76	+/-0.030	40.76	1			
15.45	+/-0.030	15.45	1			
66.51	+/-0.030	66.51	1			
70.45	+/-0.030	70.45	1			
90.41	+/-0.030	90.41	1			
91.56	+/-0.030	91.56	1			
0.050	+/-0.010	.046	1			
Ø0.516	+0.008/-0.001	Ø.518	1			
1.80	±.030					

Measured by: <i>DC</i>	Checked by: <i>DAS 38</i>	QC Inspector:
Date: 16/10/24	Date: OCT 25 2016	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ	
B	11.04.28	Dimensions updated per Dwg Rev B	KJ	
C	12.05.24	Dimensions updated per Dwg Rev C	KJ	
D	12.07.31	Dwg Rev updated	KJ	
E	12.09.26	Dimensions updated per Dwg Rev E	KJ	
F	16.03.17	Dwg Rev updated	KJ	

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-041	WEARBAR ASSEMBLY



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WORK ORDER

NO. 152 484 MWS

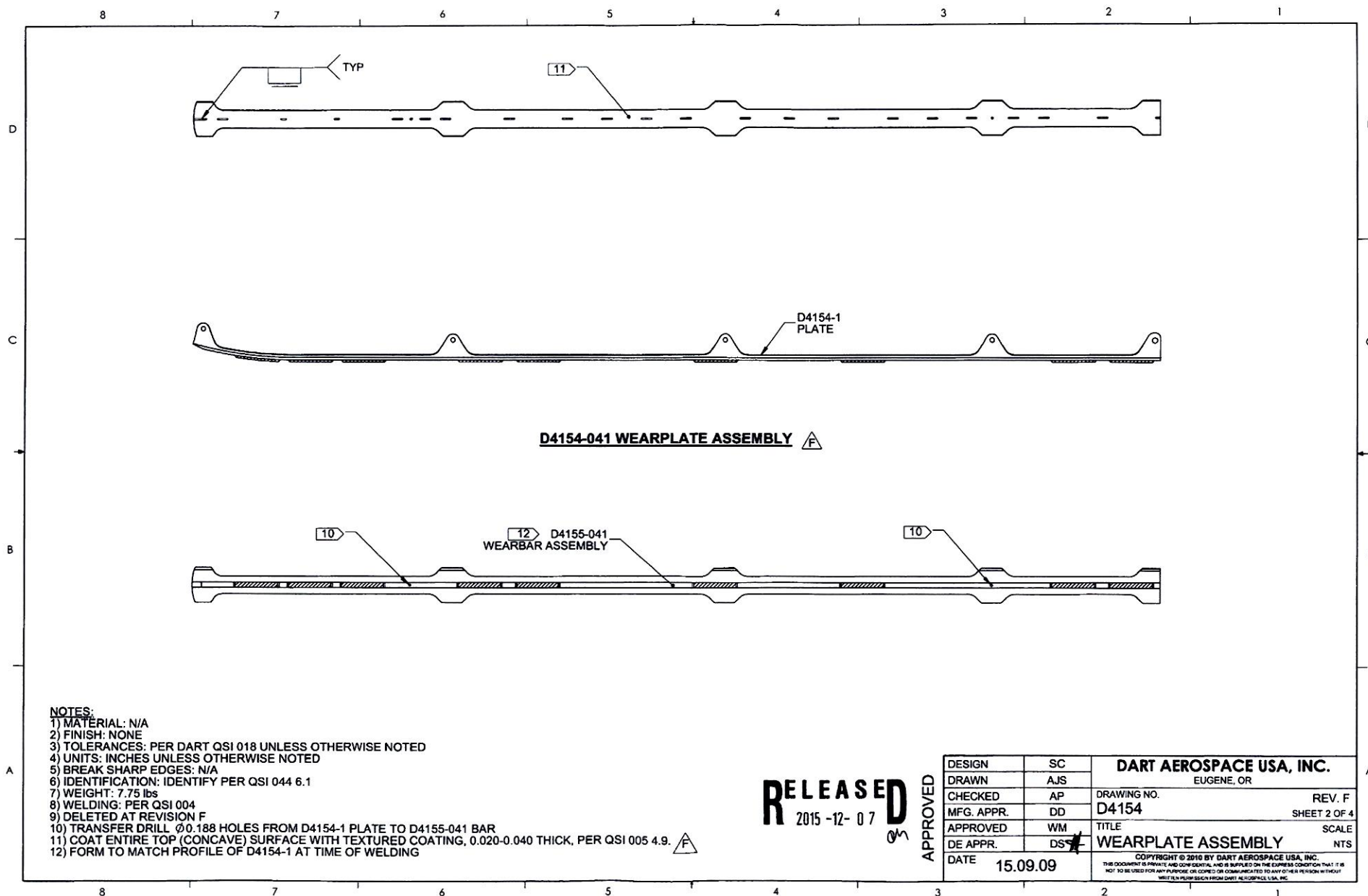
167024

D4154-041 WEARPLATE ASSEMBLY

F	TEXTURED COATING WAS ROCKGUARD (SHT 2). SHT 4 DIMENSION FROM SLOTS WERE CENTER TO CENTER. CREATED CUSTOM FLAT PATTERN AFTER PROTOTYPING DUE TO WELDING SHRINKAGE SEE CIRTS-41. HARDCOAT WELD MOVED TO D4155 DRAWING DUE TO CHANGE IN WELDING. D4155-041 WAS D4155-1.	AJS	15.09.09
F	SHT 3 SLOTS RE-PITCHED (PAR 12-213). 0.32 WAS 0.37	AJS	12.08.07
D	70.45 WAS 74.45 & Ø0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2); ADD HARDCOAT (ZN B7-2); ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. F
MFG. APPR.	DD	D4154	SHEET 1 OF 4
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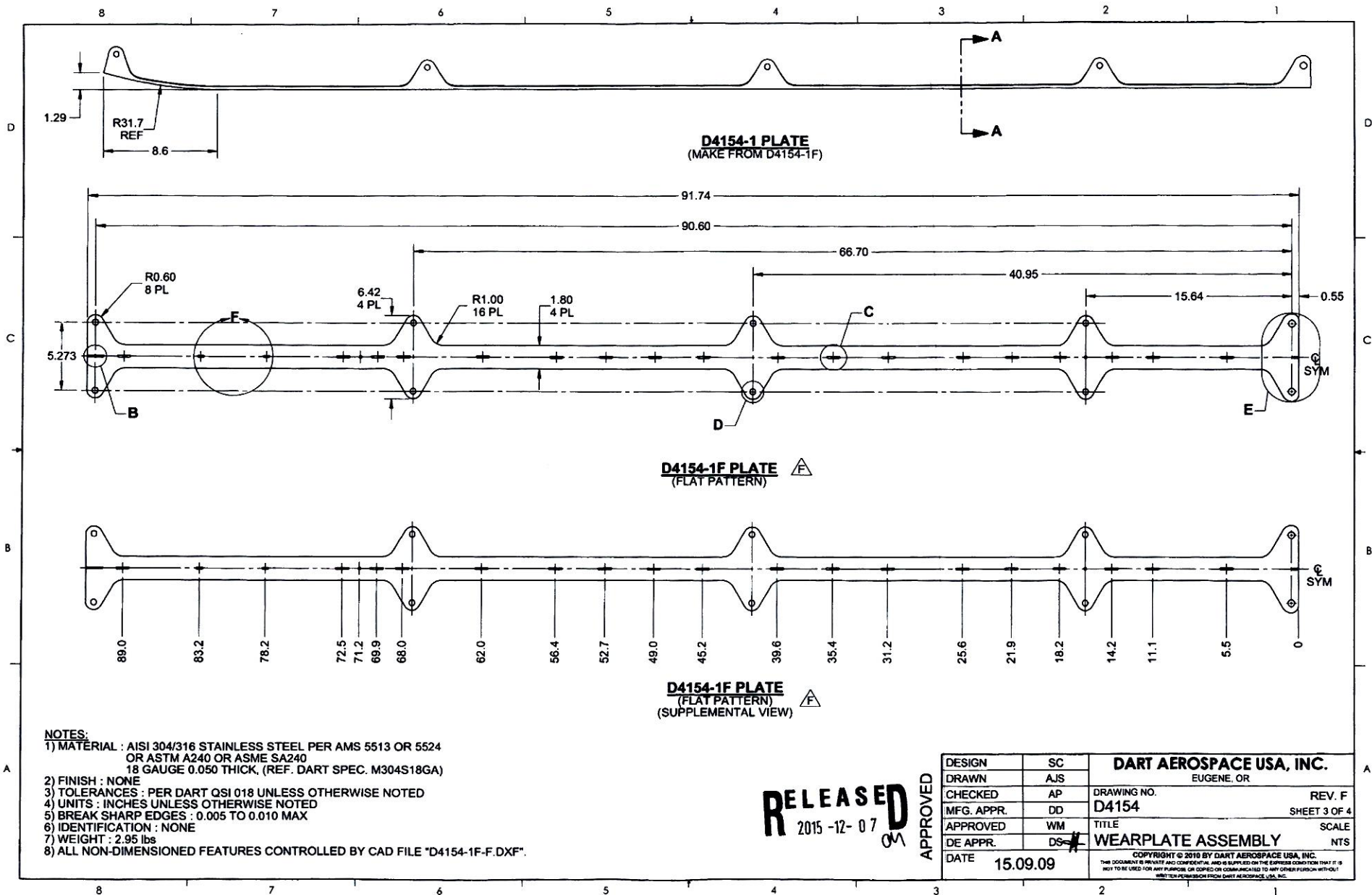
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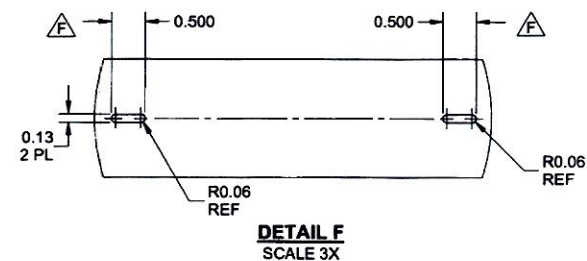
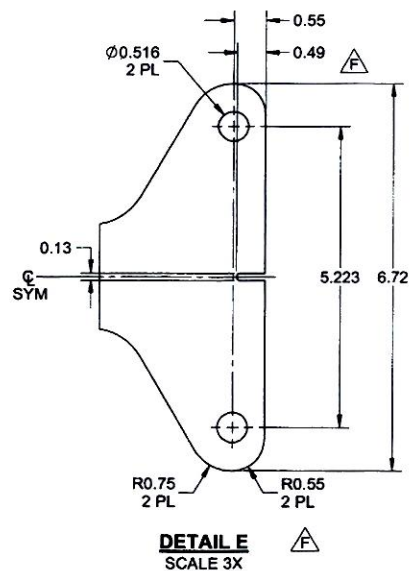
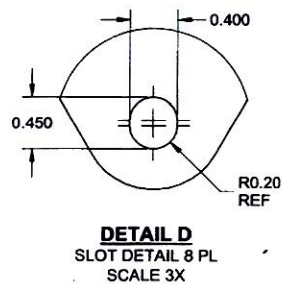
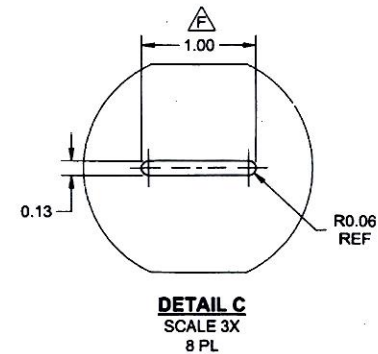
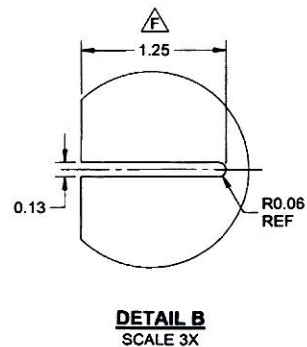
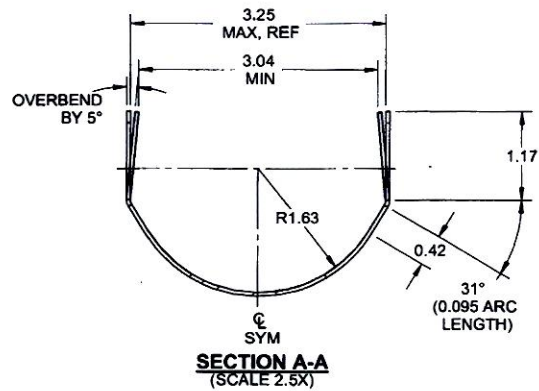
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